

shp 15/04

Dart Aerospace Ltd.

Date: Wednesday, 3/26/2008 1:46:25 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R/H LOW PROFILE BASKET BASE ASS'Y
Job Number : 38217	
Estimate Number : 13171	
P.O. Number :	Part Number : D3712042
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3712 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 37525	Material :
Written By :	Due Date : 4/16/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est Rev:A new issue 08-01-30 DD verified by:EC	
Est Rev:B chg to revB ecn 1145 08-03-19 DD verified by:	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)  
304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3726-1	<u>M1075014</u>
2	D3727-1	<u>M107514</u>
2	D3734-1	<u>M107514</u>
6	D3735-1	<u>M107514</u>
3	D3739-1	<u>M107514</u>
3	D3740-1	<u>M107514</u>

2- deburr

JD 08/03/31

2.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spacer Bushing  
batch 336479

Pl 08-03-31

3.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Mounting Bracket  
batch 337248

Pl 08-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B38169

*Pl 08-03-31*

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch B37305 → 1 B38225 → 2

*Pl 08-03-31*

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch: B37611

*Pl 08-03-31*

7.0

D37591

BUSHING



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

BUSHING

batch B37603 → 8

*Pl 08-03-31*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- take D3166-1 and trim as per dwg D3746 to make D3746-1, D3746-3, D3746-5 and D3746-7

2- take D3746-3, D3746-5, D3746-7 and drill holes as per dwg D3746 - *FL 08 03 31*

3- drill holes in both D3727-1 as per dwg D3727 - *FL 08 03 31*

4- drill holes in D3735-3 as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

*Pl 08-04-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38217

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description Batch

38sq.ft M304EX0.75-16F Expanded Metal

M167514

Pl 08.04.02

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745

Pl 08.02

2- weld mesh as per dwg D3712

2H 08/04/03

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.04.07 (1)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08.04.07 (1)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107550

Pl 08.04.07

(1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/04/08 (1X)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bumper *B 21139*

*✓ ml*

17.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt *M 14820*

*✓ ml*

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer *M 107091*

*✓ ml*

19.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Washer *M 107534*

*✓ ml*

20.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Cherry Rivets *M 18071*

*✓ ml*

21.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut *M 106883*

*✓ ml*

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3712

*ml 06/04/08*

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08601 07 (R)*

*2 x D3757-1 B 38008*

*per Blue file u*

*ml*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38217

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

MP 38216

8/4/9

SCA (A)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-10  
u

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

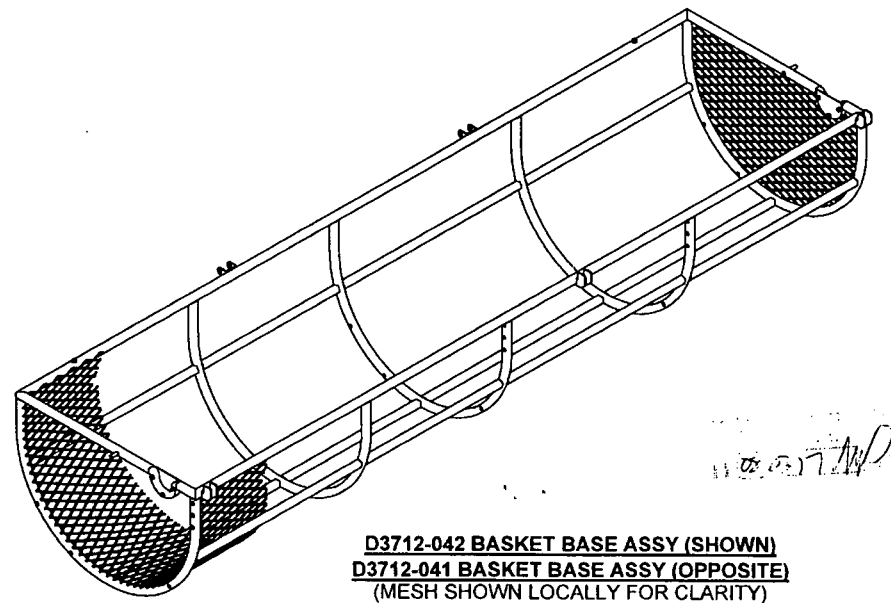
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
△ B X		D3712-041	BASKET BASE ASSEMBLY
	X	D3712-042	BASKET BASE ASSEMBLY
2	2	D2327-3	SPACER BUSHING
2	2	D2581	MOUNTING BRACKET
△ B 2	2	D2931	BUMPER
2	2	D3725-1	HOOP
2	2	D3726-1	RIB
2	2	D3727-1	RIB
2	2	D3734-1	RIB
5	5	D3735-1	RIB
1	1	D3735-3	RIB
3	3	D3739-1	RIB
3	3	D3740-1	RIB
1	1	D3744-1	MESH
1	1	D3746-1	RIB
1	1	D3746-3	RIB
2	2	D3746-5	RIB
1	1	D3746-7	RIB
3	3	D3748-1	HINGE HALF
2	2	D3757-1	BLANKING PLATE
△ B 21	21	D3759-1	BUSHING
△ B 6	6	AN3-11A	BOLT
△ B 2	2	AN960JD8	WASHER
△ B 12	12	AN960JD10	WASHER
2	2	MS20600AD4W3	RIVET
6	6	MS21042L3	NUT

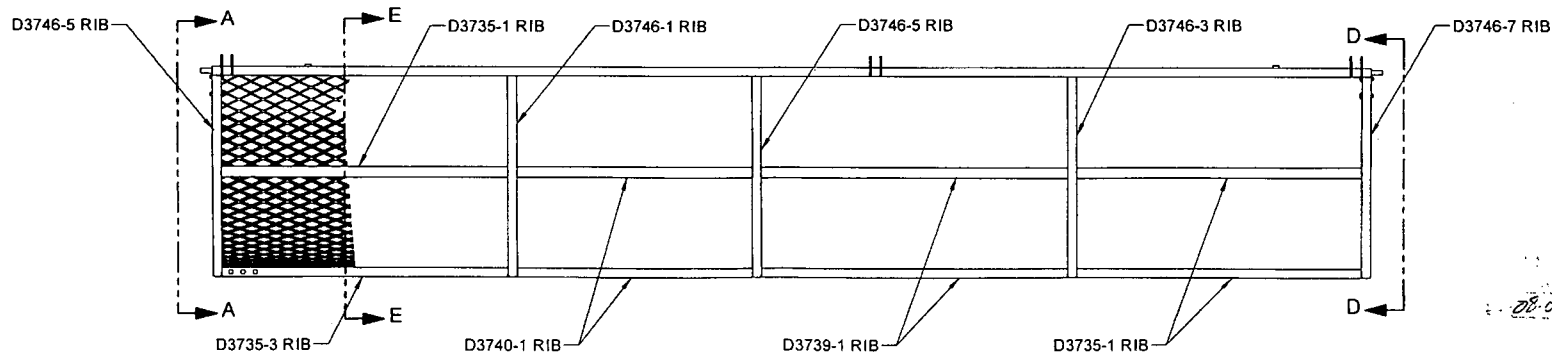
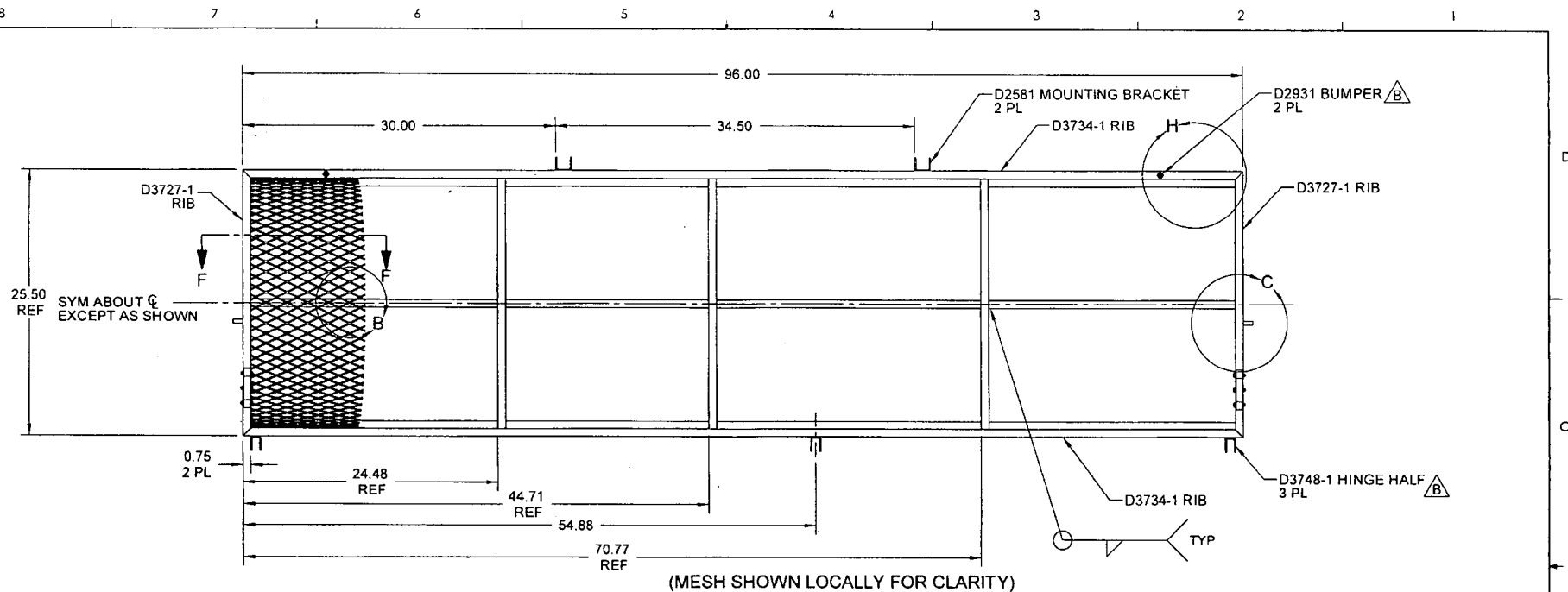


**D3712-042 BASKET BASE ASSY (SHOWN)**  
**D3712-041 BASKET BASE ASSY (OPPOSITE)**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) WELDING: PER DART QSI 004
  - 9) MASK ALL HOLES PRIOR TO POWDER COATING.

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WITHOUT NOTICE  
WORK ORDER  
NO. 38217

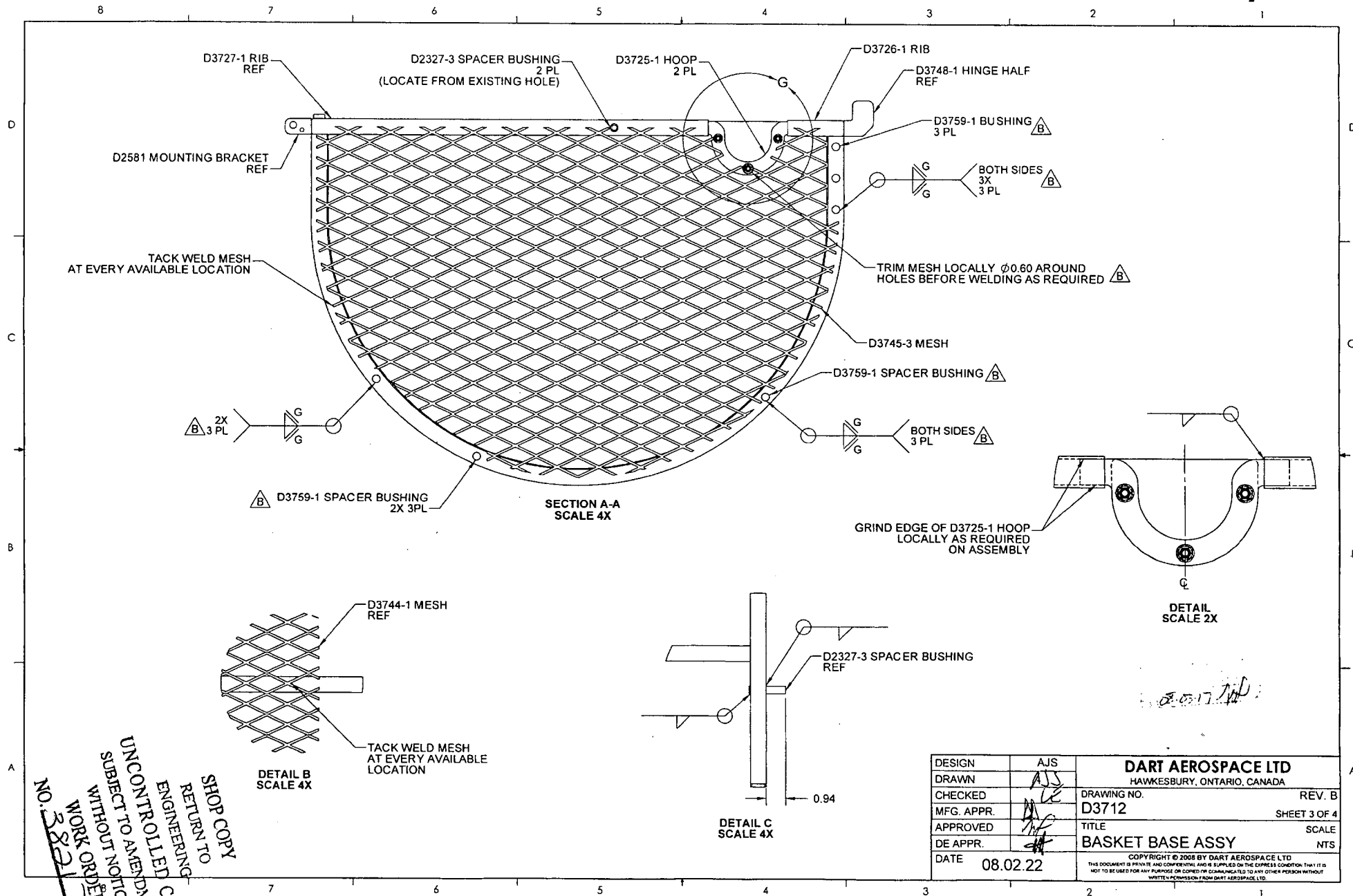
B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4. ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.	AJS	08.02.22
A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	CE		
MFG. APPR.	DS		
APPROVED	MP		
DE APPR.		DRAWING NO. <b>D3712</b>	
DATE	08.02.22	TITLE <b>BASKET BASE ASSY</b>	
		REV. B SHEET 1 OF 4 SCALE NTS	
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9 D3712-041 BASKET BASE ASSY (OPP)  
 9 D3712-042 BASKET BASE ASSY (SHOWN)

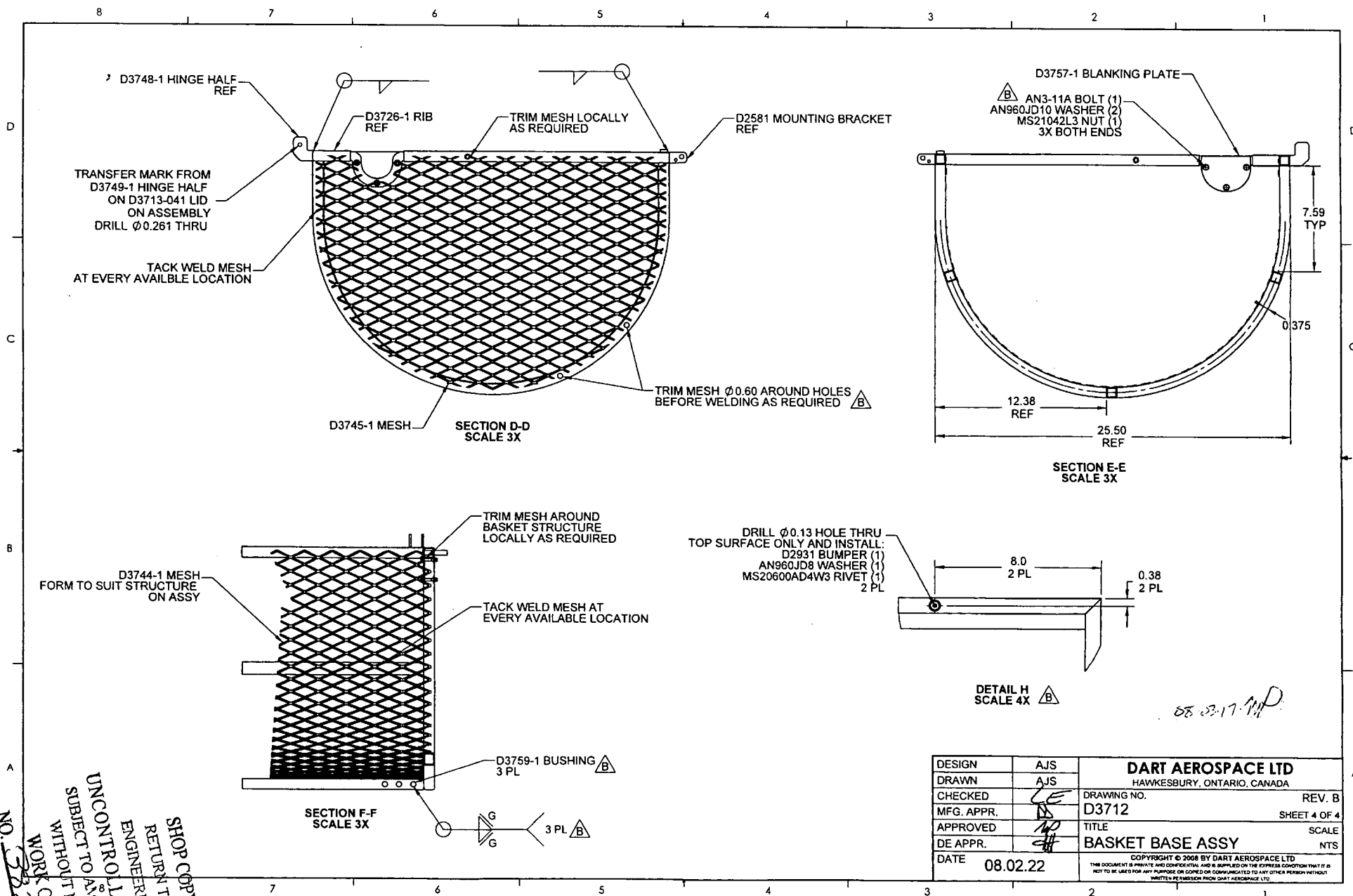
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MFG. APPR.	AS	D3712	SHEET 2 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSY	NTS
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NO. 38217

WORK ORDER

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MFG. APPR.	DS	D3712	SHEET 4 OF 4
APPROVED	TH	TITLE	SCALE
DE APPR.	CH	BASKET BASE ASSY	NTS
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